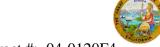
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-000507 Address: 333 Burma Road **Date Inspected:** 22-Sep-2007

City: Oakland, CA 94607

OSM Arrival Time: 2215 Project Name: SAS Superstructure **OSM Departure Time:** 830 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Xu Lefend **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** 114 Meter Mock-Up

Summary of Items Observed:

This Quality Assurance Inspector observed welding of longitudinal plate mp1004, 70 millimeters thick to plate MA113, 60 millimeters thick for 114 Meter Mock-Up, Face D Skin Plate Sub-Assembly. Welding procedures utilized were WPS-B-T-2232-TC-U5-F by ZPMC Welder, Cao Henjin, welder identification 66420 and WPS-B-T-2232-TC-P5-F by ZMPC welder Weng Yanyan, welder identification 066734. The ZPMC Quality Control Inspector/Certified Welding Inspector was Xu Lefend who was assisted by Wang Xingpin. The Quality Control Inspector from American Bridge Builders/Flour was Hua Li Wei. All welding appeared to be in compliance with the special provisions and applicable welding procedures. Work on the project was halted at approximately 0145 for the evening.

Summary of Conversations:

A conversation was held with Quality Assurance Inspector Larry Viars on the pier concerning elevation 77. ZPMC quality control personnel ultrasonically tested the complete joint penetration weld number 3 between plate mp2, which is 75 millimeters in thickness and plate MA2, which is 90 millimeters in thickness. The full length of the T-joint weld was measured and found to be 2000 millimeters and one major defect was marked out by quality control and it measured approximately 880 millimeters long which was calculated to be 44% of the entire length weld. There were several smaller indications also marked out on the weld.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Inspected By: Berger,Bruce Quality Assurance Inspector **Reviewed By:** Cochran,Jim QA Reviewer